



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		1P385	42/60
3	Pallet Die No.		V.T-L M/C Shop	Drg No- LSP 586
4	Die Category	Drg. No.	1P350 (3.5mm)	CRV 00
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	780mm Step 00, 802mm	Step length - 30mm
7	Width of Pellet Die	Drg. No.	660.12mm	Tapper 10°
8	Grooves as per Drawing	Drg. No.	290mm	Under cut = 11mm
9	Fitting Sizes on CNC Plate	Drg. No.	27x8x7.5mm 27x8x7.5mm	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 12 Both Side
11	Tapping Operator		OK	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		724mm	
14	Tapping On Second Side	Half pitch of 1st side	M 22 check by M 22 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth - 29.3mm Tapping Depth - 27.5mm	
17	Visual Inspection Before Gun Drilling		Yes	

Inspected By (Sign) & Date

Ramanjeet Singh 20/07/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 60°
ROW - 43

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.0mm	outside (3.3)	Inner			
3	External Relief Depth		25mm	18mm			
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		20	07	24		

Inspected By (Sign) & Date

Ramanjeet Singh 20/07/24

Signature
22/7/24

Reviewed by (Engineer-CNC)

Manager-QA